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**CENTRAL INTELLIGENCE AGENCY**

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COUNTRY    USSR (Moscow Oblast)

REPORT

SUBJECT    1. The Borets Petroleum Machinery Plant    DATE DISTR.    1 May 1959  
              2. Trekhgornaya Textile Combine

NO. PAGES    1

REFERENCES

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DATE ACQ.

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SOURCE EVALUATIONS ARE DEFINITIVE.    APPRAISAL OF CONTENT IS TENTATIVE.

Two reports on industrial installations in Moscow

Attachment 1

the Borets Petroleum Machinery Plant. This includes a sketch of the plant layout and a diagram of the tool shop. Attachment 2 concerns the Trekhgornaya Textile Combine, describing generally the plant buildings and production methods. This report also includes a sketch of the plant layout and a diagram of the plant organization.

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29 MAY 1959

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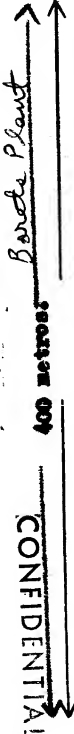
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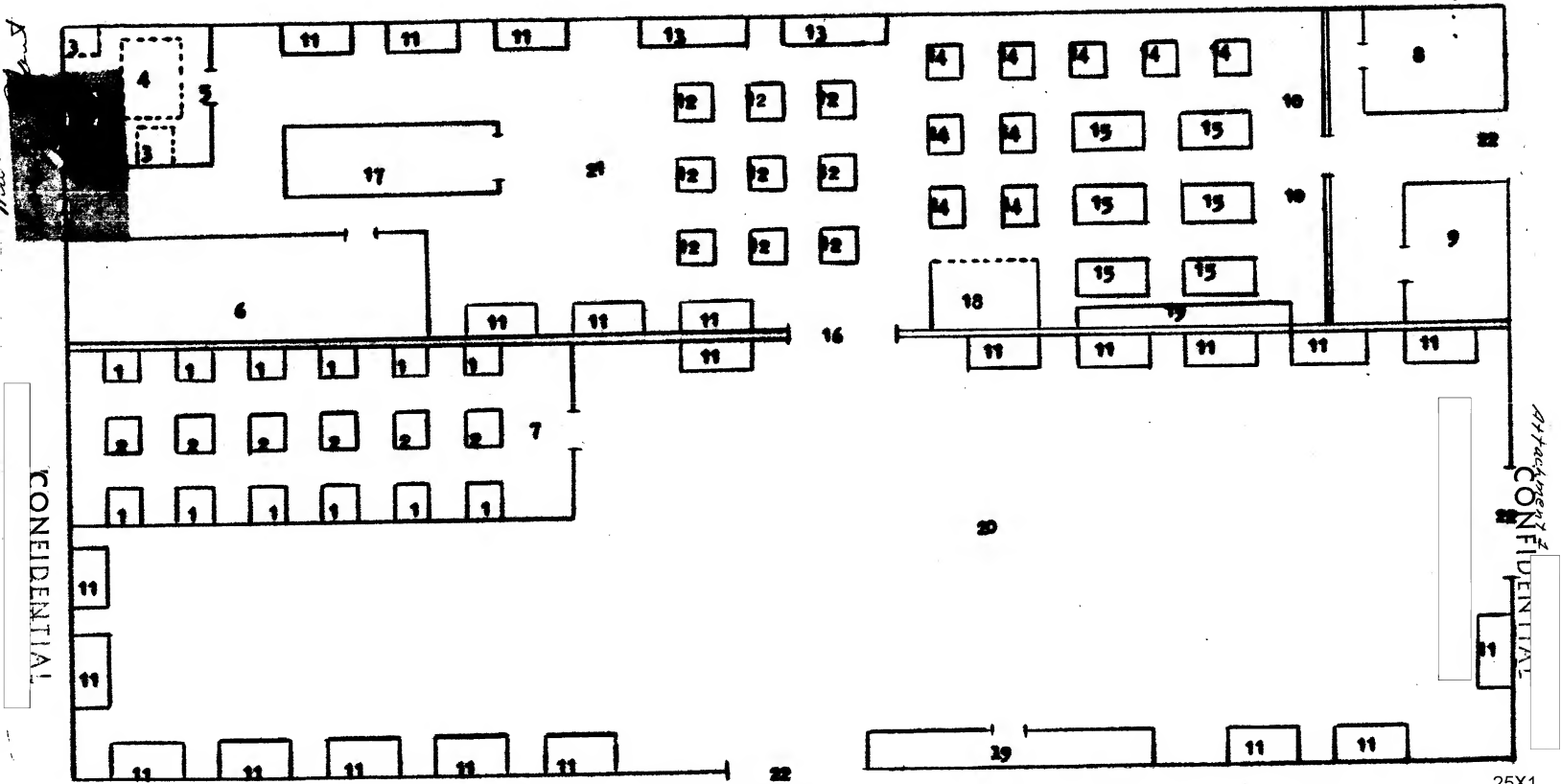
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BORIETS PLANT THAT MANUFACTURED MACHINERY FOR THE PETROLEUM INDUSTRY

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The Boriets (1 - which means "fighter") Plant was located in Moscow, Dzerzhinsky

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rayon, on Skladochnaya (3) ulitsa № 6.

This plant manufactured machinery such as, pumps and compressors for the petroleum industry.

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The plant had a perimeter of 1900 meters.

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The Security Station (1/1) was located in a small wooden building and had 15 employees.

The Personnel Entrance (2/1) had a barred window through which two or three guards checked "propusks" of employees.

The Dining Room was located at the point (3/1) indicated on sketch.

The Welding Shop (4/1) handled work usually furnished by the foundry. Parts which could not be cast in one piece were welded into one block in this shop.

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The Supply Warehouse (5/1) was used for storing sheet metal, ingots, and other supplies for shop use.

The Bachelor's Quarters (6/1) ~~was~~ located in a 50 X 30-meter two-story brick building that had a sheet metal roof. On each floor, ~~there were~~ 12 rooms, each with a capacity for 10 or 12 beds.

The Foundry (7/1) was located in a 200 X 150-meter brick building which had columns 10 meters high that supported the glass roof. It had two <sup>(coal)</sup> furnaces and iron smokestacks, eight or ten meters high. This installation cast raw materials into parts which were transported to corresponding shops by electric carts.

Machine Shop No 1 (8/1) was a 200 X 130-meter building that had the same characteristics as the Foundry. It manufactured loose parts for pumps and compressors and sent them on to the Assembly Shop. It had old Russian-manufactured lathes, milling machines, drills, etc. which were in good condition and an overhead travelling crane.

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The Repair Shop (9/1) was located in a 60 X 30-meter shop building that had a glass roof. It repaired lathes. It had 15 lathes and ~~complementary~~ <sup>auxiliary</sup> machinery such as drills, mandrills, planes, etc.

The Tempering Shop (10/1) was entered through the Repair Shop. It had six fuel oil furnaces pushed up against the wall where parts were tempered and then submerged in an oil bath, located in the center of the room. Eight employees worked on each of its three shifts.

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The Reservoir (11/1) measured 50 X 40 X 3 meters.

Machine Shop No 2 (12/1) was located in a 100 X 40-meter building that had a glass roof. It manufactured smaller parts than those of Machine Shop No 1.

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Each shift had 300 workers.

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Machine Shop No 3 (13/1) had the same characteristics and manufactured the same type of article as Machine Shop No 2; ~~it~~ sent the parts by electric carts to the Assembly Shop. Each shift had 300 workers.

The Carpenter Shop (14/1) was located in a 80 X 20-meter building, handled work for the Crating Shop and work for <sup>(living)</sup> quarters that the plant was constructing some distance away near the Savelovskiy railroad station.

The Assembly Shop (16/1) was located in a 250 X 100-meter building that had a glass roof. It had an overhead travelling crane, but no machinery. Work benches that had a vise were pushed up against the wall. This shop assembled pumps and compressors supplied by Machine Shops No 1, 2, and 3.

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Compressors measured 2 X 2'5 or 3 X 1 meters.

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(4) ATTACHMENT 1  
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These were stamped "Boriets", painted grey, and loaded on trucks which transported them either to their destinations or to the railroad siding where an overhead travelling crane (15/1) loaded them on freight cars.

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The Tool Shop (17/1) was located in a 100 X 25-meter brick fireproof building that had a glass roof. It manufactured finished tools such as: cutting tools, drills, power shovels, test milling machines, drill stocks, diestocks, etc. The plant had a tolerance of two hundred parts of a centimeter.

This shop had eight furnaces in the tempering section and an oil basin in the center.

It had the following machinery:

25 lathes

12 or 14 milling machines

6 planes

3 drills

(See sketch N° 2.) Most of the machinery was Russian manufactured except for five lathes and two milling machines of foreign make. The machinery was adequate and in good condition. Occasionally old lathes were replaced by new ones.

The "widia" and "ceramic" lathe cutting tools that the plant used were manufactured in another plant.

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The plant had

been utilizing these cutting tools since 1914.

This shop had 300 workers on the two day shifts and 150 on the night shift.

The plant did not have any secret installations or bomb shelters.

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Attachment 2

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The Main Administrative Offices (21/1) were located in a two-story brick building

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that had a sheet metal roof. Offices of the Director, Secretary, Sub-Director,

Engineers, Designers, Draftsmen, etc. were located here.

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The Truck Entrance (22/1) opened on the main street which led to all installations.

The Club (23/1) was located on a corner of the premises.

#### RAW MATERIALS

The plant used ingots of steel, bronze, high speed steel, stainless steel, and

cast iron;

It also used coal and <sup>heavy</sup> ~~materials~~

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oil for fuel. The plant did not receive foreign ~~materials~~, assembled, or nearly

assembled <sup>supplies</sup> ~~materials~~.

<sup>(and coal)</sup> Ingots <sup>(heavy)</sup> were brought right inside the premises by rail. Small quantities of oil,

used only for tempering, were brought in oil trucks.

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Water was supplied to the plant from an unknown place in Moscow.

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#### POWER

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Electricity was supplied to the plant from unknown power <sup>plants</sup> ~~plants~~ in Moscow. The plant

(6) Attachment 2

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did not generate its own power but transformed it and distributed it to the different

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sections and shops.

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## TRANSPORTATION

The plant had a one-track normal width railroad siding which connected with the

main Moscow line that came from nearby Savelovskiy (4) station.

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It ended at the point (15) indicated on

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sketch; an overhead travelling crane lifted loads from the trucks onto the ordi-

nary freight cars. No construction work to extend facilities was going on.

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Access to the plant was through Skladochnaya(3); it was about 15-meters wide

asphalted, in good condition, trafficable, and adequate.

The plant had about 20 trucks. It did not have a garage only a sort of portico

where quick repairs were handled and a parking <sup>(area)</sup> around it. Large truck repairs

were handled

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1. TRANSPORTATION

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1. Supplies and raw materials were brought in by rail and finished products

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\_\_\_\_\_ were shipped to their destination by rail. Trucks entered and left frequently

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\_\_\_\_\_ Trucks were also used for transportation within the plant, for example,

from one shop to another. They sometimes hauled finished products from the assembly

shop to the railroad cars, when the electric cars regularly used in this operation

could not handle the extra weight. No river transport was used.

2. STORAGE: Each shop had a small stockroom in which parts and material used

there were stored. However, no provision was made for storing finished machinery

on the plant premises. It was hauled directly to railroad cars to be shipped

to its destination.

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3. ASSEMBLY LINE:

\_\_\_\_\_ raw materials were brought to the foundry in ingots, and cast into

the forms or parts required. From here they proceeded to the respective shops

to be polished, turned, planed, and finished. Completed parts were sent to the

Assembly Shop, and dispatched as described above. Control devices were the usual

kind used for this type of installation. \_\_\_\_\_

4. WORK SCHEDULE:

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The plant worked a six day week throughout the year. The working day was

divided into three eight-hour shifts. Workers got fifteen days paid annual

vacation. Those who had debilitating jobs were given thirty days annual vacation.

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5. SECURITY

Scarcely any security measures were taken within the plant.

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Each dog had a radius of movement of about sixty meters.

To enter the plant one had to display an entrance pass, or "propusk", which was issued from the personnel office. This was a small card folded in two sections bearing the name and photograph of the owner. Since this checking of the pass was the only means of controlling entry, it was done thoroughly.

The folded sides of the card were always opened and the ~~XXXXXXXXXXXX~~ worker's identity checked with the photograph. If the pass were forgotten entry was denied, even to someone well-known to the guards.

Those other than plant personnel who wanted to enter had to avail themselves of a special pass, obtainable through the personnel office with the OK of the director. The time<sup>of</sup> entry and proposed length of stay were noted on this pass.

If the time limit was exceeded, investigation was promptly made.

6. FIRE PREVENTION:

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Uniformed firemen constantly

patrolled the plant, checking electrical outlets and equipment and cautioning the workers against carelessness in handling of lighted cigarette butts, etc.

They were also instructed in more extensive methods of fire prevention. The firemen regularly checked their own equipment as well, which consisted of hoses

and hand extinguishers.

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7. PERSONNEL:

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Plant personnel consisted of the following: A director and assistant director who substituted in the former's absence, two secretaries, machine construction engineers, economists, planning engineer, head of the purchasing department, draftsmen, designers, accountants, and other office personnel.

A total of ten thousand persons worked in the plant, twenty per cent of

which were women.

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Names of personnel

were:

GERASIMOV Plant director.

IVANOV Inu Head of the Plant Party Office,

ABRAHAM Inu Chief of the tool shop.

ALEKSEY Inu Assistant chief of the tool shop.

SASA Inu Foreman of the tool shop,

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8. PRODUCTION

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Attachment 2

Constant efforts were being made to increase production volume

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The machinery was always being replaced by more efficient and

up-to-date models.

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LEGEND TO THE SKETCH NO. 1

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- |                                 |   |
|---------------------------------|---|
| 1. Sentry station               | 19. Open-air dumps for sand, iron, & wood |
| 2. Personnel entrance           | 20. Personnel office                      |
| 3. Dining room                  | 21. General offices                       |
| 4. Gas welding                  | 22. Truck entrance                        |
| 5. Materiel warehouse           | 23. Club                                  |
| 6. Bachelor's quarters          | 24. Garage                                |
| 7. Foundry                      | 25. Dogs                                  |
| 8. Machine shop no. 1           | 26. Rotunda with statue of Lenin          |
| 9. Repair shop                  | 27. Open air parking lot                  |
| 10. Furnaces and tempering shop | 28. Garden                                |
| 11. Reservoir                   | 29. Railroad                              |
| 12. Machine shop No. 2          |   |
| 13. Machine shop No. 3          |   |
| 14. Carpentry shop              |   |
| 15. Crane and Railroad terminal |   |
| 16. Assembly shop               |   |
| 17. Tool manufacturing shop     |   |
| 18. Railroad entrance           |   |

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## LEGEND TO SKETCH NO. 2

1. 1. Emery wheels
2. Sharpeners
3. Tempering furnaces
4. Tempering vats
5. Tempering shop
6. Tool warehouse
7. Sharpening and hollow grinding shop
8. Storeroom for metal stock
9. Shop offices
10. Low wall
11. Work benches with vises
12. Milling machines
13. Drills
14. Ordinary size lathes
15. Planers
16. Communication door for both shops
17. Machines (fitting)
18. Control table
19. Washrooms, cloakroom
20. Assembly shop
21. Tool shop
22. Entrances

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Attachment 2

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**TEXTILE COMBINE "TRUKHOMAYAYA" IN MOSCOW****Identification and Location**

1. [redacted] 25X1

The plant was also known as [redacted] (Three Mountain Factory) [redacted]

The plant was located on the Rodelskaya [redacted] Number 13, in the Krastopresnenskiy Rayon, and occupied an area about 500 x 300 meters in dimension. There had been no change in the plant location since its construction nor has there been any new construction to [redacted] 25X1

[redacted] The plant was subordinate to the Ministry of Light Industry.

**Description**

2. This plant, which had been established prior to WWI, was owned by (Zmu) Morozov, until the 1917 Revolution. During the pre-World War I period the plant had the reputation of being one of the best textile plants in Moscow, and it still enjoyed that reputation in 1957. Some of the machines used in 1957 were from the pre-World War I days, but were in good condition. After 1918 many new machines of Czech, Polish, [redacted] 25X1 East German and Russian manufacture, varying in year of make from 1920 to 1950, were mounted in the plant.
3. The plant had modern fluorescent lighting which was installed in 1948. The buildings had many large windows, and were well heated by a central heating plant. The machines were kept in good mechanical condition, and the individual shops were clean. [redacted] 25X1

**Buildings and Their Activities**

4. Refer to page 13 [redacted] sketch of the plant layout. 25X1

Point 1. Plant railroad station and marshalling yard. This was a railroad freight station connected to the Moscow railroad net used exclusively by the plant. There were five tracks, standard USSR wide gauge, and five loading platforms. The length of the platform was about one kilometer. A narrow gauge spur led from this station to the individual shops of the plant.

Point 2. Storage warehouses. A storage warehouse was located on each of the five loading platforms. Each warehouse was a one-story wooden building about 100 x 10 x 8 meters in dimension, with a flat tin roof. [redacted] 25X1

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- [redacted] 25X1
- Point 3. Fence. A wooden fence, about 2 meters high was located along the western and eastern side of the plant area. There was no fence along the northern plant boundary which bordered on Rodelskaya [redacted], and only a small section of the southern boundary was fenced since the main factory building occupied the southern portion of the plant grounds. 25X1
- Point 4. Gate for railroad and truck traffic. Two guards were on duty at this gate at all times, including holidays.
- Point 5. Street. [redacted] 25X1  
[redacted] It could have been Trekhgorniy Pereulok. This street separated the railroad station from the plant. 25X1
- Point 6. Spinning shop. A three-story, red brick building about 50 meters long x 40 meters wide with a gabled tin roof. [redacted]  
[redacted] the shop contained long spinning machines of Czech and Russian make, and that about 200 women worked there during each shift. The building had a [redacted] freight elevator with a platform ten meters by seven meters in size. Three to five mechanics were always on duty in this shop. 25X1
- Point 7. Administration Building and Billets. A three-story, red brick building, about 50 x 40 meters in area dimension, with a gabled tin roof. On the first floor were offices for the director, bookkeeping section, typing section, and for the chief of the Special Section. About 30 people worked there. On the second and third floors there were living quarters for employees of the plant. Each floor had 56 rooms, each about 30 meters square, containing 10 beds. About 25 [redacted] women lived there. There were separate rooms for families, for men, and for women. 25X1
- Point 8. Main Gate. Entrance for all employees. There were two guards posted at this gate at all times.
- Point 9. Personnel Office. A one-story, red brick building, about 10 meters square, with a tin gabled roof. From three to five women worked there issuing passes and work books to new employees, keeping track of accounts, pay, leaves, etc.
- Point 10. Rodelskaya [redacted] 25X1
- Point 11. Weaving shop. A three-story, red brick building, about 50 x 40 meters in area dimension, with a gabled tin roof. Each floor had about 150 weaving looms of Czech, East German, Polish and USSR make. [redacted] 25X1  
[redacted] About 20 to 25 women worked on each floor. The building had a [redacted] elevator. At all times five mechanics were present for preventive maintenance of the machinery. A brick ramp led from the second floor of this 25X1

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building to the bleaching shop in the basement (point 25, page 13 ).

- Point 12. Narrow gauge railroad line leading inside the plant to various buildings.
- Point 13. Roads inside the plant.
- Point 14. First aid station. A two-story, red brick building, about 20 x 10 meters in area dimension, with a gabled tin roof. On the first floor were first aid rooms and offices for the nurses. On the second floor there were about 50 cots for the convenience of employees who wanted to remain in the plant for their next shift.
- Point 15. Garage. A one-story, red brick building, about 20 x 15 meters in area dimension, with a gabled tin roof. It had space for seven trucks. The plant had ten trucks, three of which were parked in the open near the garage.
- Point 16. Main Repair Shop. A two-story, red brick building, about 50 x 30 meters in area dimension with a gabled tin roof. On the first floor were ten lathes, four milling-cutting machines, two planing machines, five electric welding stands, and one electric saw. There was a timekeeper on the first floor, to whom all mechanics surrendered their passes. Approximately 150 mechanics worked here - one shift only. On the second floor there were 30 machinist's work benches.
- Point 17. Storage. A two-story, red brick building, about 70 x 50 meters in area dimension with a gabled tin roof. It contained finished bolts of cloth, which were later packed in trucks. There was a narrow, wooden, portable ramp which was set up to load the bolts of cloth in the trucks. [redacted] about 20 or 30 men and women worked there during each shift.
- Point 18. Restaurant. A one-story, red brick building, about 50 x 20 meters in area dimension with a gabled roof. It had a seating capacity of 200 and workers were served on staggered hour schedule. About 40 or 50 women were employed in this restaurant which was open during all shifts.
- Point 19. Park. This was an area 100 meters square with trees, benches and a statue of Felix Dzerzhinskiy.
- Point 20. Designing shop. A one-story, red brick building, about 70 x 30 meters in area dimension, with a gabled tin roof. [redacted] about 20 or 30 men worked there, during one shift only, making flowered and other designs and patterns for the printing of the various cloths.

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- Point 21. Storage.** A one-story, red brick building, about 50 x 30 meters in dimension, with a gabled tin roof. It served as a storage room for finished merchandise. From this point the bolts of cloth were loaded [redacted] and pushed by hand to the railroad siding, point 1, page 13 [redacted]. [redacted] about 50 to 60 men and women worked there on each shift. In the east section of this building, there was a fire engine, with pumps, ladders, etc. There was always one fireman on duty. 25X1
- Point 22. Communist Party Offices.** A two-story, red brick building, about 50 x 20 meters in area dimension, with a gabled tin roof. On the first floor there were the offices of the Party Organizer of the plant, meeting rooms, etc. The payroll section was located on the second floor. 25X1
- Point 23. Repair shop.** A one-story, red brick building, about ten meters square, with a gabled tin roof. [redacted] it contained three lathes, two drilling machines, one electric saw, two work benches, all of Soviet make. Three to five mechanics were there at all times including Sundays. These mechanics worked only on maintenance of the bleaching machines. 25X1
- Point 24. Bleaching, trimming, dyeing, printing and sorting shops.** A three story, L-shaped, red brick building, with a gabled tin roof. One wing, hereafter referred to as point 25, was about 40 meters square, and the other wing, hereafter referred to as point 26, was about 200 meters long and 40 meters wide. This was the main factory building, and the only building in the plant which had a basement. It also had two freight elevators [redacted] with platform space about 10 meters x seven meters in size. 25X1
- Point 25. Bleaching and trimming shops.** In the basement, which was connected with a ramp from the second floor of point 11, woven cloth was stored until taken by an elevator to the bleaching shop. On the first floor were four roller-machines, where the woven cloth was treated with natural gas to remove threads, felt, etc. One woman serviced each machine. There were also ten huge vats where the woven cloth was rinsed with an acid and/or caustics. One man and two women attended each vat. The first floor had also 35 bleaching stands of East German and Soviet make. One woman attended each stand. After the cloth underwent these processes, it was pulled up to the second floor by rollers. There the cloth was placed on drying drums. Each drying drum was attended by three women. There were ten such drying drums on the second floor. There were also on the second floor 50 trimming stands, mostly of East German make, where the cloth was again cleansed of hair, threads, other ruffage. One woman attended three trimming stands. There were also three to five mechanics on constant duty to insure continuous operation of the

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trimming machines. Rollers pulled the cloth to the third floor, where there were about ten drying drums, each attended by three women. The third floor had also a control section where about 30 women inspected the cloth to insure uniform quality.

- Point 26. Printing, dyeing and sorting shops. The eastern part of this building was occupied by the printing shop. This shop was located in an area about 40 meters square. On the first floor were 20 printing stands. One woman operated three such stands. Rollers pulled up the printed cloth to the second and third floors. On each of the second and third floors there were 10 drying drums, each drum attended by two women. On the third floor there were also about 10 women who inspected the finished product. There were three to five preventive maintenance mechanics always on duty in the printing shop. The center of the building, an area about 100 by 40 meters, was occupied by the dyeing shop. On the first floor were 10 dyeing vat-stands, each attended by five women. Rollers pulled the dyed cloth to the second and third floors. On both the second and third floors there were seven drying drums, each drum attended by two women. There were also from 10 to 20 women on the third floor who inspected the dyed cloth. Five mechanics were always on duty in the printing shop for preventive maintenance and emergency repairs. The dyes were stored on the first floor, and were pumped in a liquid state into the dyeing vats. The western wing of the building, an area about 60 x 40 meters, was occupied by a sorting shop. On all three floors women sorted, measured, folded, and

wrapped up the finished bolts of cloth. about 100 women worked during one shift on all three floors.

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- Point 27. Water Reservoir. Outside of the plant area, near the Moskva River, stood a cylindrical cement tank filled with water. This tank was about 15 meters high, and had a diameter of about 30 meters. Water for the bleaching, trimming, printing and dyeing processes came from this tank.

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- Point 28. Underground pipes drained off the dirty water, into the Moskva River. The plant had also a furnace room which supplied heat to all plant buildings.

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#### Plant Activities

5. The following materials were produced at the plant: flannel, tulle, calico, artificial silk, crepe-de-Chine, halfsilk material, satin, linen, cotton-cloth, Shtapel (a mixture of nylon, rayon and silk), silk ribbons, material for flags, ready made bedlinen (sheets and pillowcases), toweling, handkerchief material, strips used for bunting, and ready-made women's scarves.

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6. The dimensions of the materials varied. Most of the cloths were either 75 centimeters or 1.50 meters in width. Ribbons and strips were from two to five centimeters in width. Material for towels and handkerchiefs came in bolts, but were perforated for cutting individual sizes: towels, 1.25 meters or one meter in length by 50 centimeters in width; and handkerchiefs in sizes approximately 40 centimeters square. Shawls were ready made, about 70 centimeters square.

7. The cloth was produced in bolts, 40 meters to 60 meters long, in all colors, such as green, blue, yellow, red, white, black, violet, and all possible hues of these colors. The material for flags was of red color. Some of the cloth was also printed in multicolored flowered or other patterns. Source could not give any data on the weights of materials. These cloths were used for underwear, shirts, linen, dresses and blouses.

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8. The plant also manufactured a khaki colored cotton cloth for the Soviet Army, from which tunics and breeches were made. This material was one meter wide, 40 to 60 meters long. Also, khaki colored canvas material, used for Soviet Army tents was produced in bolts 1 1/2 meters wide, length unknown.

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only a small percent of production was for Army use. The item produced in greatest quantity, "Shtapel", was used for ladies blouses and dresses. However, the linen, towels, handkerchiefs might have been for military as well as for civilian use.

#### Raw Materials

9. The following raw materials were brought to the plant: cotton, dyes, various chemicals, (such as caustics, acids) wood and coal for heating. The point of origin of the above mentioned raw materials was unknown. the coal came from the Don Basin area. These raw materials were brought daily to the plant in railroad cars.

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In addition to the raw materials mentioned above, the finished cloth bolts were stored at the plant.

#### Water Supply

10. The plant had a reservoir (point 27, page 13 ) of unknown capacity for water supply. The bleaching shop (point 25, page 13 ) had 10 pumps to pump water from this reservoir to bleaching vats, and also to dispose of the used water.

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The water was conducted by underground pipelines. Diameter, length and capacity of the pipelines were not known.

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#### Power

11. The electric power came from the Moskva Heat and Power Plant TETS 7,

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directly behind the Textile Combine. [redacted]

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[redacted] The amount of electricity was adequate. There were no emergency generators. About two or three times a month there was electric failure, when all machinery stopped until the failure was repaired. The repair required about half an hour's time on the average. There were no connections from this plant with any dams.

#### Packing

12. Merchandise shipped from this plant to other plants in Moscow was packed in wooden boxes, about 1 x 1 x 3 meters in dimension. [redacted]

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[redacted] The word "KANTON" was stamped on the outside of the above described wooden boxes. The boxes were sealed with a leaden seal (Plomba).

#### Transportation

13. On the west side of the plant, on the opposite side of the street (exact name unknown, possibly the Trekhgorniy Pereulok), there was a special railroad station with about 5 tracks for this plant only. These tracks were connected with the Moscow railroad ring and were of the standard Russian gauge. A narrow gauge track led from these tracks to the inside of the plant, to the spinning, weaving, dyeing shops and to the storage areas. (See point 12, page 13 ). [redacted]

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14.

[redacted] Most of the finished products were shipped from the plant by train. Except for bolts of cloth woven in other factories and brought to this plant for dyeing and/or printing, all incoming material arrived by train.

15. The roads inside the plant area shown as point 13 on page 13, were asphalt covered, about three meters wide, and could sustain loaded ZIS and GAZ trucks. These adequately constructed roads were always used during unloading and loading and operations.
16. The plant had 10 trucks, five ZIS-150 models and five GAZ-Molotov models. These trucks were maintained in the garage, shown as point 15, page 13 . [redacted]

25X1

[redacted] The trucks brought materials from other shops for dyeing and printing, and delivered finished bolts of cloth or scarves to factories and stores in Moscow. Only a small (unknown) percentage of materials were brought in or dispatched by truck. Two wooden boxes, as described in para. 12 above, were placed on one truck. There was no means of water transportation for this plant.

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Storage

17. There was no open storage area at this plant. There were two storage buildings inside the plant area, described as points 17 and 21, pages 13 , and a storage area at the special plant railroad siding, described as point 2, page 13 .

25X1

Assembly Line

18. Cotton brought to the plant by rail was sent to the spinning shop, and came out from the spinning shop as thread on spools approximately eight inches long and three inches thick. These spools were taken to the weaving shop, and the thread was woven into bolts of cloth of varying widths and lengths. The bolts of cloth were bleached, and trimmed of threads and lint. The cloth was then dried. The cloth was then either printed or dyed, and after another drying process, the cloth was sorted, measured, and packed for shipment. The finished merchandise was stored in two storage buildings inside the plant area, and was distributed from there.

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19.

From the weaving shop the cloth was taken over a ramp to the basement of the bleaching shop, and from there by a freight elevator to the bleaching shop. Inside the bleaching shop there were rollers which pulled up the cloth to the second and third floors for cleansing, trimming and drying.

25X1

These shops also had rollers which pulled up the dyed or printed cloth to the second and third floors for drying. Dyes were kept near the dyeing/printing shops, and were pumped in a liquid condition into the dyeing vats.

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20. trucks transported the finished merchandise to its final destination. At each stage there were from 10 to 30 women who inspected the work.

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Production

21.

The weaving shop had about 150 weaving looms on each of its three floors, making a total of 450 weaving looms. Since the average woman worker attended five to twelve looms and averaged 200 meters production daily in an eight hour period, 55 women attending 450 looms would have turned out 11,000 meters in one shift, or a total daily production of 33,000 meters for the three shifts.

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22. In addition to the above described woven output, the plant also received bleached cloth for printing/dyeing from the following installations:

- a. The Izmilov Factory (Izmilovskaya Fabrika), 3rd Parkovaya Ulitsa, Stalinakiy Rayon, Moscow. This factory made cloth from cotton, but did not have a printing and dyeing shop. All printing/dyeing for this factory was done at the Textile Combine.
- b. The Shchelkov Factory (Fabrika Imeni Shchelkova), Moscow, [redacted] 25X1  
[redacted] This factory, which also made cloth, had no dyeing/printing shops, and sent cloth for dyeing/printing to the Textile Combine. 25X1
- c. The Frunze Factory (Fabrika Imeni Frunze), Moscow (exact address unknown). This factory made cotton fabrics as well as expensive silks and silk for parachutes. Only the cotton cloth was sent to the Textile Combine for printing/dyeing. The silks were sent to another unknown plant for printing/dyeing. [redacted] 25X1

23.

24.

#### Labor Force

- 25. The employees worked 48 hours weekly. The plant operated in three shifts, six days weekly. All workers were rotated in the three shifts. The administrative personnel, office help, pattern makers, drivers and the mechanics working in the main repair shop worked only on one shift, from 0900 to 1800, with one hour off for lunch. The hours for the shifts were: 0700 - 1520, 1520 to 2340, 2340 to 0700. Each shift had 30 minutes for lunch. The night shift (2340 to 0700) worked only seven hours. [redacted] about 850 people worked on each shift. 25X1
- 26. Each worker was given 18 days leave with full pay annually, to be taken at the time desired by the worker. Up until 1950 the plant closed in August for three or four weeks for machine repairs and maintenance, and the workers took their leave in August, but there were no shutdowns after 1950, and leave was given at any time desired.
- 27. Wages for the average female spinner, weaver or other worker averaged 1200 rubles monthly. They were paid according to the amount of work they actually produced. The weavers were paid from 0.10 rubles to 1 ruble per meter according to the width, type and quality of the cloth. The average pay was 0.30 - 0.40 rubles per meter. 25X1
- 28. [redacted] a semi-skilled mechanic-machinist, earned 500 to 750 rubles per month. [redacted] basic pay was 500 rubles per month, and in addition [redacted] received 25X1

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a bonus if there were no machine breakdowns in the bleaching section. Skilled mechanics earned five or six rubles per hour. Chief mechanics earned from 1700 to 3000 rubles per month. The office clerical personnel individually earned about 500 to 600 rubles per month.

25X1

29. Sanitary conditions were good in the plant. There were sufficient toilets, dressing rooms, and a first aid station (See point 14, page 13 ). The factories had fluorescent daylight lighting, a window placed at every eight or ten meters of wall space, and the rooms were well heated.

#### Security

30. The factory had a Special Section, believed to have been subordinate to MIB. The chief of the special section always wore civilian clothes. Subordinate to him were from 20 to 25 guards. Two guards were on duty at all times at the main gate, and near the RR and vehicular gate (See points 4 and 8, page 13 ), and two guards patrolled the plant area.

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The guards wore regular Army uniforms, but without shoulderboards. Those stationed at the gates had pistols (make unknown) while the men patrolling the area carried rifles (make unknown).

31. Each worker had to show his plant pass to the guards at the main gate. The pass was a cardboard document about 4 x 3 inches in size, which contained the name, photo and number of each worker. Upon entering the plant, the worker showed his pass to the guards, and then surrendered his pass to the timekeeper of his particular shop. At the end of the workshift the timekeeper returned the pass to the worker, who showed it to the guards at the main gate. The guards would require each worker, who carried a bag or package, to present the bag or package for inspection. Most people entered only the buildings containing their respective workshops.

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32. The plant had also about five uniformed firemen, and a fire truck (See point 21, page 13 ). Most buildings had manual fire extinguishers.

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#### Organization and Personnel

33. Refer to page 14 , a chart of the organizational structure of the plant.

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"trouble shooters" worked in three shifts, and also on Sundays, with a working week day off. Each shop (spinning, weaving, bleaching, dyeing, printing) had about five "trouble-shooter" mechanics for each shift. The plant had mostly skilled workers. There were 5 mechanic-apprentices in the plant. The breakdown in specialties is given in the T/O chart, page 14 .

34. the following supervisory personnel:

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a. Chief of all mechanics, was KAVALEV(fnu),

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b. The director was a woman, name unknown, [redacted]

c. The assistant to KAVALEV was Lev ABRAMOVICH, [redacted]

d. Chief of the "trouble shooter" mechanics was Igor Andreyevich LATUNOV,

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e. Assistant to LATUNOV was Vasilii Ivanovich BARICH, [redacted]

35. Until 1950 there were about 20 male Albanians, [redacted] who were employed in this plant. These workers repatriated to Albania in 1950. No prisoners or convicts or foreigners other than those described above, worked in this plant.

36. [redacted] workers received some form of longevity pay above the normal piece-work rates, about five percent for each five years service in this plant. Spoilage of material was a frequent occurrence, [redacted]

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37. There were relatively few instances of machinery breakdowns. Each machine was taken out, completely overhauled once a year, and reinstalled. This work was done in the main repair shop, shown as point 16, page 13, where about 150 mechanics accomplished the repair work. There were always 10 to 15 various machines in the repair shop awaiting overhaul which took from 10 to 15 days. Besides this regular maintenance, each shop had about four "trouble shooters". [redacted]

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[redacted] it took from two to eight hours to put the machine back into operation. If possible, the "trouble shooters" repaired defective machines on Sundays.

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#### Deficiencies; Improvements and Promotion of Production

38. [redacted] besides occasional machinery breakdowns or power failure described above, [redacted] no shortages or stoppages. The machines were in good condition. The plant production could be converted to wartime production on a moment's notice.

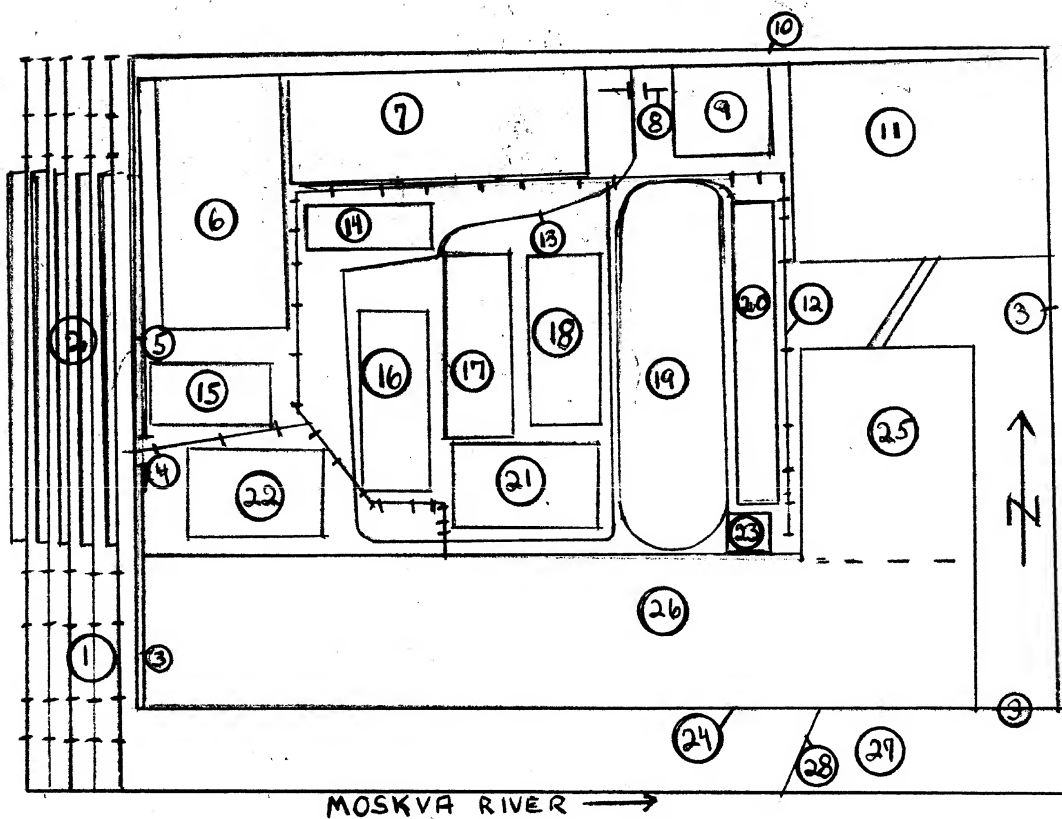
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Textile Combine Tselkhovskaya  
Plant Layout

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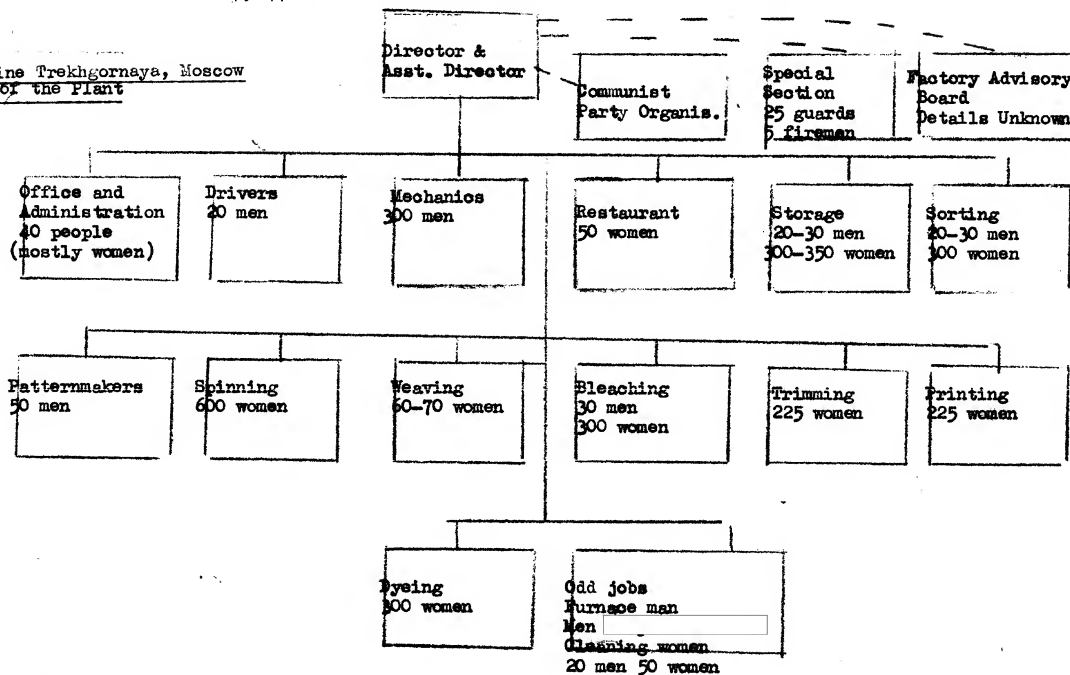
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Attachment 2

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Attachment 2  
Textile Combine Trekhgornaya, Moscow  
Organization of the Plant



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--- Not subordinate to the Plant Director  
— Subordinate to Plant Director

Rough estimate - 2500 women, 500 men

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